

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014493**Date Inspected:** 28-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint WD1-A28A/B-68 located on PCMK west tower, base shear plate assembly, outer connection plate to stiffener. Welder was identified as 054069. QC was identified as ZPMC CWI Li Lin (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2331-TC-P4-F.

FCAW welding of weld joint WD1-A28A/B-66 located on PCMK west tower, base shear plate assembly, outer connection plate to stiffener. Welder was identified as 053116. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2331-TC-P4-F.

FCAW welding of weld joint WD1-A28A/B-55 located on PCMK west tower, base shear plate assembly, outer connection plate to stiffener. Welder was identified as 052075. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was

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not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2331-TC-P4-F.

OBG Trial Assembly Area

SMAW welding of weld joint TR2A-PP50-002 located on OBG PCMK 7BW, traveler rail hanging support.

Welder was identified as 205098. QC was identified as ZPMC CWI Zhu Zhong Hai (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhu Yuan Yuan, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2212-TC-U4c.

Bay 11

This QA Inspector randomly observed no apparent welding related work being performed in Bay 11.

Heavy Dock

ABF Representative Zhao Ying Sheng informed this QA Inspector that no work was being performed on the heavy dock. This QA Inspector observed that the lift 1 sections of south and east towers had been moved off the heavy dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George
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Quality Assurance Inspector

Reviewed By:	Dawson, Paul
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QA Reviewer
